

Date: Monday, 02/02/2009 3:46:58 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: D119 HELI UTILITY BASKET
Job Number	: 45426 ✓		
Estimate Number	: 12452		
P.O. Number	:	Part Number	: D119756041 ✓
This Issue	: 02/02/2009 S.O. No. :	Drawing Number	: IIN PG11-12
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : LARGE FAB ASSY	Drawing Revision	: C
Previous Run	: 45425	Material	:
Written By	:	Due Date	: 15/03/2009 Qty: 1 Um: Each
Checked & Approved By	: <u>JLD 09.02.03</u>		
Comment	: Est Rev: A New Issue 06-06-14 JLM		
	: Est Rev. B 06.07.26 dwg revB, picklist EC		
	: est rev C revC dwg 07.04.09 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: Photocopy bluefile & type labels per PPPD119-756-041 CHG 002

2.0	45426A	BASKET LID ASS'Y (A119)
-----	--------	-------------------------



Comment: Sub-Component BASKET LID ASS'Y (A119) SUB-COMPONENT
 1 x D3515-041 Batch: 45426A

3.0	45426B	BASKET BASE ASS'Y (A119)
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Comment: Sub-Component BASKET BASE ASS'Y (A119) SUB-COMPONENT
 1 x D3516-041 Batch: 45426B

4.0	D2022101	Spacer
-----	----------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Spacer
 Batch: 39880

5.0	D2258220	Placard
-----	----------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Placard
 Batch: 30810

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: D119 HELI UTILITY BASKET

Job Number: 45426

Part Number: D119756041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2332041

Lid Prop Assembly 6.69" long



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Lid Prop Assembly 6.69"

Batch: 93721

h

7.0

D2530

Handle Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Handle Weldment

Batch: 93799

h

8.0

D2535

Spring



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spring

Batch: 39670

h

9.0

D2537

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bushing

Batch: 39153

h

10.0

D2931

Bumper



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bumper

Batch: 21139

h

11.0

D35191

Placard



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

placard

Batch: 37642

h

12.0

AN316A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: 1157737

Page 17

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 45426

Part Number: D119756041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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13.0	AN47A	Bolt
------	-------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Bolt
Batch: M108928

CU

14.0	AN422A	Bolt
------	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Bolt
Batch: M107715

CU

15.0	AN424A	Bolt
------	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Bolt
Batch: M108255

CU

16.0	AN517A	Bolt
------	--------	------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Bolt
Batch: M110363

CU

17.0	AN960JD416	Washer
------	------------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Washer
Batch: M110523

CU

18.0	AN960JD416L	Washer
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Washer
Batch: M107008

CU

19.0	AN960JD516	Washer
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Washer
Batch: M110363

CU 9/2/12 O

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 45426

Part Number: D119756041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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20.0	AN960JD8	Washer
------	----------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M110382

[Signature]

21.0	AN9704	Washer
------	--------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Batch: M110704

[Signature]

22.0	MS20600AD4W3	Cherry Rivets
------	--------------	---------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Cherry Rivets

Batch: M104715

[Signature]

23.0	MS21042L3	Nut
------	-----------	-----



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch: M109798

[Signature]

24.0	MS21042L4	Nut
------	-----------	-----



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M109282

[Signature]

25.0	MS21042L5	Nut
------	-----------	-----



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M110382

[Signature]

26.0	D37571	Blanking Plate
------	--------	----------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Blanking Plate

batch 38770

[Signature] 9/2/08 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 45426

Part Number: D119756041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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27.0	AN311A	Bolt
------	--------	------



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

batch

M/09927

28.0	AN960JD10	Washer
------	-----------	--------



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Washer

batch

M/10835

29.0	MS21042L3	Nut
------	-----------	-----



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Nut

batch

M/09798

30.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
------	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D119-756

31.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

32.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

33.0	D119756011	Clamp
------	------------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

CLAMP KIT

Batch:

37599

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 45426

Part Number: D119756041

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

34.0	D26173	Bushing
------	--------	---------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
Bushing 44360

35.0	D26175	Spacer
------	--------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)
Spacer 21251 x 3 B45663 x 1

36.0	D35161	Clevis
------	--------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
CLEVIS
batch: 37609

37.0	D35171	Strut
------	--------	-------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
STRUT
Batch: 31802

38.0	D3518041	Strut Assembly
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s) B45567
FWD ARM ASSEMBLY
Batch: ~~15567~~ in Ass'y 1091420

39.0	D35201	Spacer
------	--------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
SPACER 37623

40.0	AN413A	Bolt
------	--------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
Bolt
Batch: 110322

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 45426

Part Number: D119756041

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

41.0	AN415A	Bolt
------	--------	------



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

Batch: 110399

42.0	AN420A	Bolt
------	--------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch: M16895

43.0	AN510A	Bolt
------	--------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch: M109752

44.0	AN960JD416	Washer
------	------------	--------



Comment: Qty.: 40.0000 Each(s)/Unit Total : 40.0000 Each(s)

Washer

Batch: M110523

45.0	AN960JD416L	Washer
------	-------------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Batch: M110153

46.0	AN960JD516L	Washer
------	-------------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M14477

47.0	MS21042L4	Nut
------	-----------	-----



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Nut

Batch: M169282

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 45426

Part Number: D119756041

Job Number:



Seq. #:

Machine Or Operation:

Description :

48.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

8 of 09/02/26 (X)

49.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D119

Location: _____

PPP Rev: _____

C

Per 26 (U)

50.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/26 (J)

Job Completion



*MF
09-02-26*

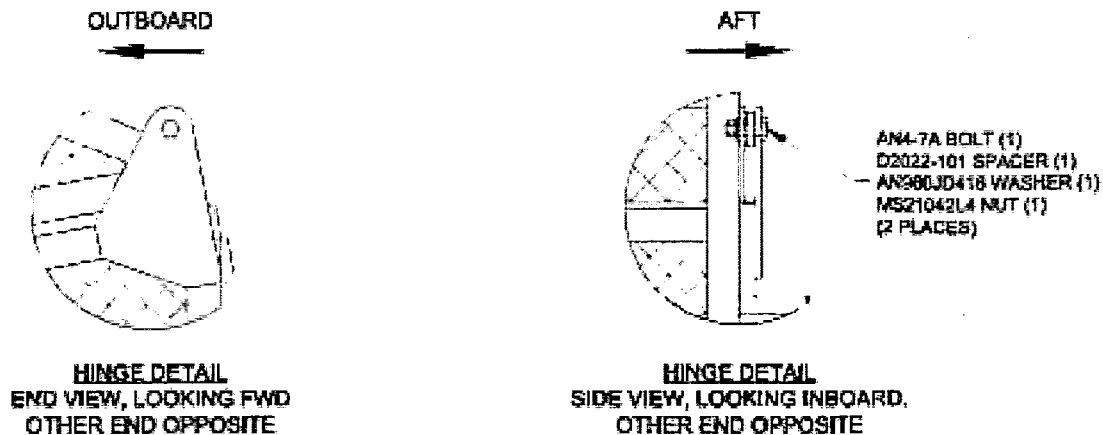
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

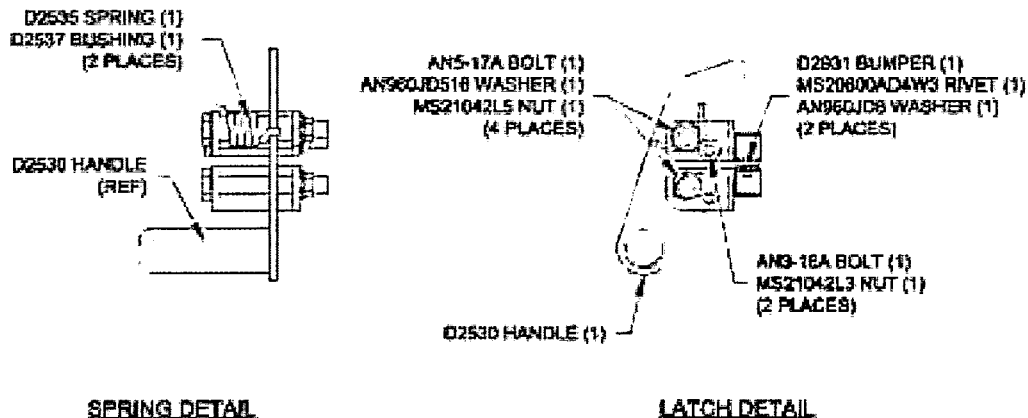
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DETAIL M: HINGE



DETAIL N: HANDLE WELDMENT

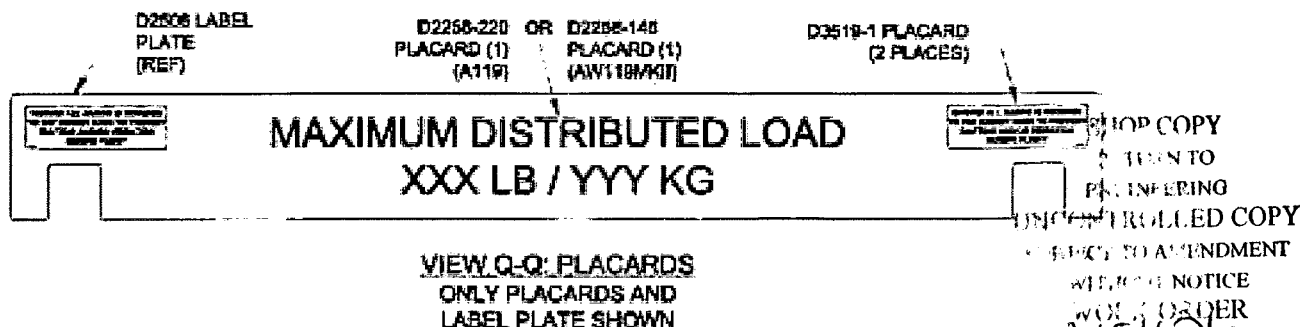


Figure 5 – Basket Replacement Parts & Placards

(D119-756-041 Heli-Utility-Basket™)

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Revision: **D**

Date: 08.05.07

5.0 WEIGHT AND BALANCE

There is a negligible weight change associated with the installation of the **D119-756-013 Quick Release Kit**. The following is the weight and balance information for the **D119-756-041 Heli-Utility-Basket™** and the **D119-756-011 Clamp Kit**.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D119-756-041 Heli-Utility-Basket™ , LH or RH on A119	118.0 lb 53.6 kg	± 46.0 in ± 1.17 m	± 5428.0 lb-in ± 62.7 kg-m	120.0 in 3.05 m	14160 lb-in 163.5 kg-m
D119-756-011 Clamp Kit , LH or RH on A119	0.8 lb 0.36 kg	± 24.5 in ± 0.62 m	± 19.6 lb-in ± 0.22 kg-m	120.0 in 3.05 m	96.0 lb-in 1.1 kg-m
D119-756-041 Heli-Utility-Basket™ , RH only on AW119MKII	118.0 lb 53.6 kg	+ 48.0 in + 1.22 m	+ 5664.0 lb-in + 65.4 kg-m	120.0 in 3.05 m	14160 lb-in 163.5 kg-m
D119-756-011 Clamp Kit , RH only on AW119MKII	0.8 lb 0.36 kg	+ 26.5 in + 0.67 m	+ 21.2 lb-in + 0.24 kg-m	120.0 in 3.05 m	96 lb-in 1.1 kg-m

6.0 POSSIBLE QUICK RELEASE PIN REPLACEMENT

Bolt	Minimum Grip	Replacement Pin P/N
AN4-15A	1.20" (30.5mm)	AVIBANK: BLC4B12S, BLC4TA12S, BLC4R12S, BLC4LA12S MS NUMBER: MS17984C412, MS17985C412, MS17986C412, MS17987C412 REID TOOLS: BLRS-020

NOTE: The qty(2) AN4-15A bolts that secure the D3517-1 Struts mounted on the Basket Base to the D3516-11 Clevises and the qty(2) AN4-15A bolts that secure the top of the Basket Base to the D3518-041 Strut Assemblies may be replaced with stainless steel positive locking quick release pins with a minimum double shear strength of 2400 lbs and 0.25" diameter (10700N and 6.4mm diameter). The **Dart D119-756-013 Quick Release Kit** can be procured from Dart to provide the necessary quick release hardware.

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WITHOUT NOTICE
WORK ORDER
NO 45426

7.0 PARTS LIST

Qty -041	Qty -011	Qty -013	Part Number	Description
X			D119-756-041	HELI-UTILITY-BASKET™
1	X		D119-756-011	CLAMP KIT
		X	D119-756-013	QUICK RELEASE KIT
2			D2022-101	* SPACER
1			D2258-220	PLACARD (A119)
1			D2258-146	PLACARD (AW119MKII)
1			D2332-041	* PROP ASSEMBLY
1			D2530	* HANDLE ASSEMBLY
2			D2535	* SPRING
2			D2537	* BUSHING
2	2		D2617-3	BUSHING
4	4		D2617-5	BUSHING
	4		D2732-032	RUBBER CUSHION
2			D2931	* BUMPER
	1		D3041-1	CLAMP (A119)
	1		D3041-3	CLAMP (A119)
	1		D3041-5	CLAMP (A119)
	1		D3041-7	CLAMP (A119)
	1		D3789-1	CLAMP (AW119MKII)
	1		D3789-3	CLAMP (AW119MKII)
	1		D3789-5	CLAMP (AW119MKII)
	1		D3789-7	CLAMP (AW119MKII)
1			D3515-041	* BASKET LID ASSEMBLY
1			D3516-041	* BASKET BASE ASSEMBLY
2			D3516-11	CLEVIS
2			D3517-1	STRUT
2			D3518-041	STRUT ASSEMBLY
2			D3519-1	* PLACARD
2			D3520-1	SPACER
2			D3757-1	* BLANKING PLATE

* indicates that part is pre-assembled on basket for customer

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NO. 45426

Qty -041	Qty -011	Qty -013	Part Number	Description
6			AN3-10A	* BOLT
2			AN3-16A	* BOLT
2			AN4-7A	* BOLT
2			AN4-13A	BOLT
6			AN4-15A	BOLT
	2		AN4-17A	BOLT
2	2		AN4-20A	BOLT
1	2		AN4-22A	* BOLT
1	2		AN4-24A	* BOLT
2			AN5-10A	BOLT
4			AN5-17A	* BOLT
2			AN960JD416	* WASHER
40	4		AN960JD416	WASHER
2			AN960JD416L	* WASHER
4			AN960JD416L	WASHER
4			AN960JD516	* WASHER
2			AN960JD516L	WASHER
2			AN960JD8	* WASHER
12			AN960JD10	* WASHER
4			AN970-4	* WASHER
		4	BLRS-020	POSITIVE LOCKING QUICK RELEASE PIN
2			MS20600AD4W3	* RIVET
8			MS21042L3	* NUT (OR MS21042-3)
4			MS21042L4	* NUT (OR MS21042-4)
10	4		MS21042L4	NUT (OR MS21042-4)
4			MS21042L5	* NUT (OR MS21042-5)

* indicates that part is pre-assembled on basket for customer

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NO. 45426

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Revision: D
Date: 08.05.07